

Date: Thursday, 4/12/2007 8:22:31 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SUPPORT ASSEMBLY
Job Number	31661	Part Number	D3278041
Estimate Number	10464	Drawing Number	D3278 REV. B
P.O. Number	N/A	Project Number	N/A
This Issue	4/12/2007	Drawing Revision	B
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	4/22/2007
Previous Run	30563	Qty:	40
Written By		Um:	Each
Checked & Approved By			
Comment	Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	31661A	SUPPORT	Net on sto INV. B31661A X 33
		Comment: Sub-Component SUPPORT D3278-1 B 30563 A X 7 ✓	
2.0	31661B	SUPPORT	Not in INV. B31736 X
		Comment: Sub-Component SUPPORT D3278-2 B 30563 B X 13 ✓	
3.0	D32783	Spacer	Not in INV. 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Spacer Pick: Qty Part Number Description Batch	B31941 X 39 B30291 X 1 ✓
4.0	MS20426AD37	RIVET	Not in INV. 
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s) RIVET Pick: Qty Part Number Description Batch	B30291 X 1 ✓ M4533 M16527 ml07/04/26
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278.	ml07/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:22:31 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 31661

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/27 (40)

7.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2230-1	Mounting Lug	B301SS

x61

~~x61~~

(\*) B 30992 (29)

8.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	M103363

✓

9.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN960JD416	Washer	M102929

✓

10.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	MS21042L4	Nut	M103914

✓

M107/05/02

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

x40

M107/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 09/05/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 31661

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/02 (y)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*AC*

7/5/2 59

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*107/05/03*

Job Completion



*AC 07/05/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

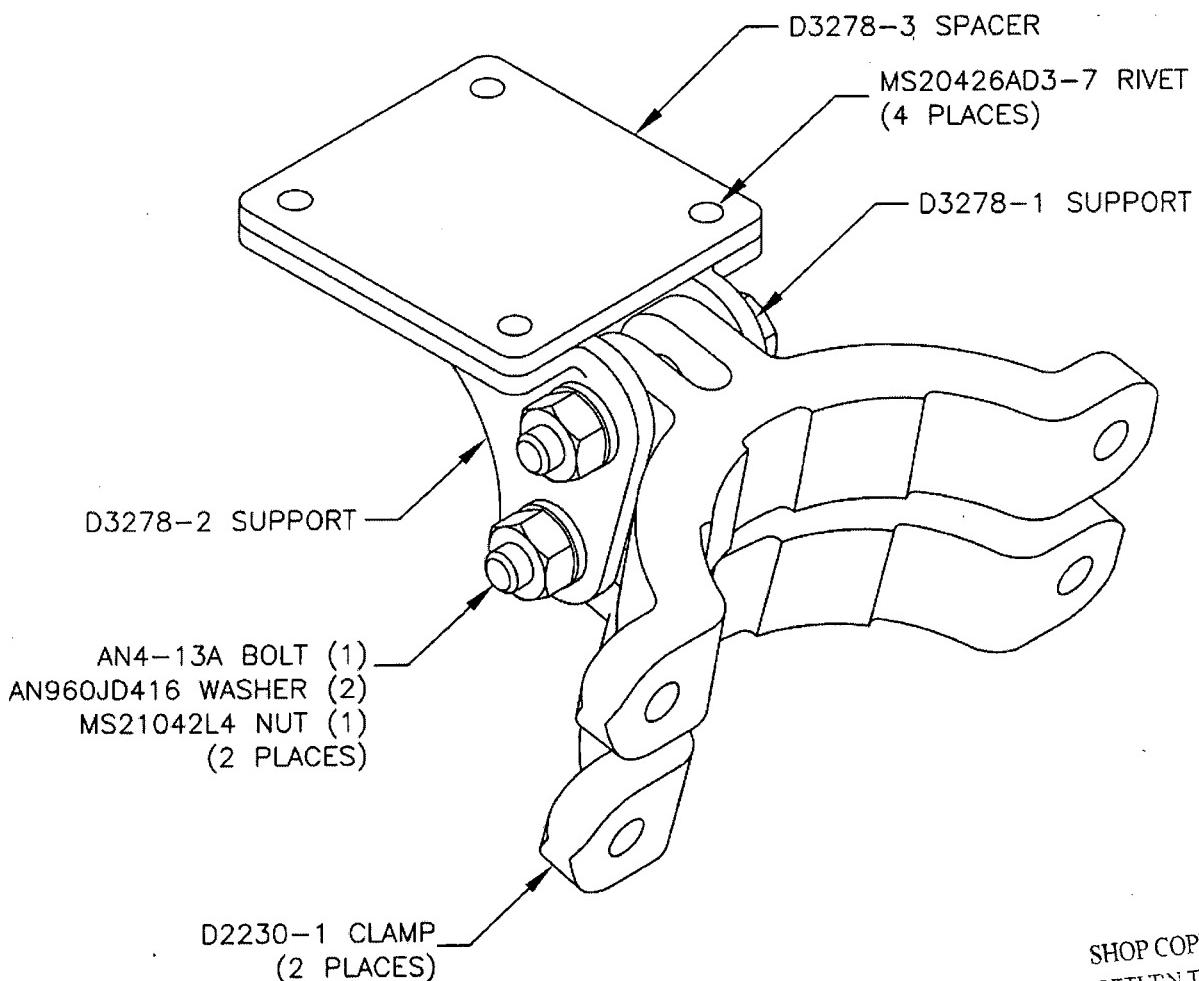
NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

**RELEASED**  
05.04.04 *[initials]*

## D3278-041 SUPPORT ASSEMBLY



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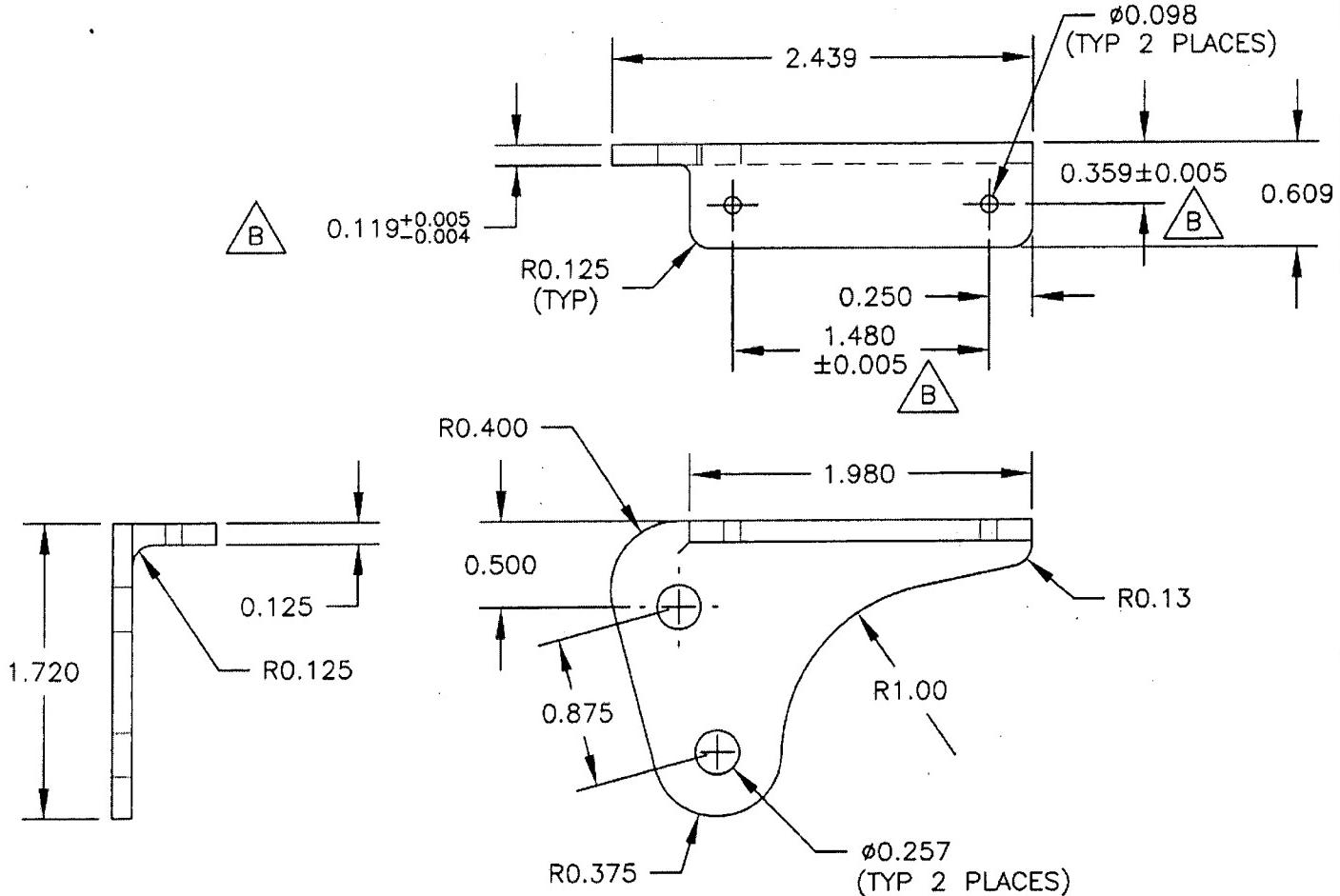
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED

05.04.04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

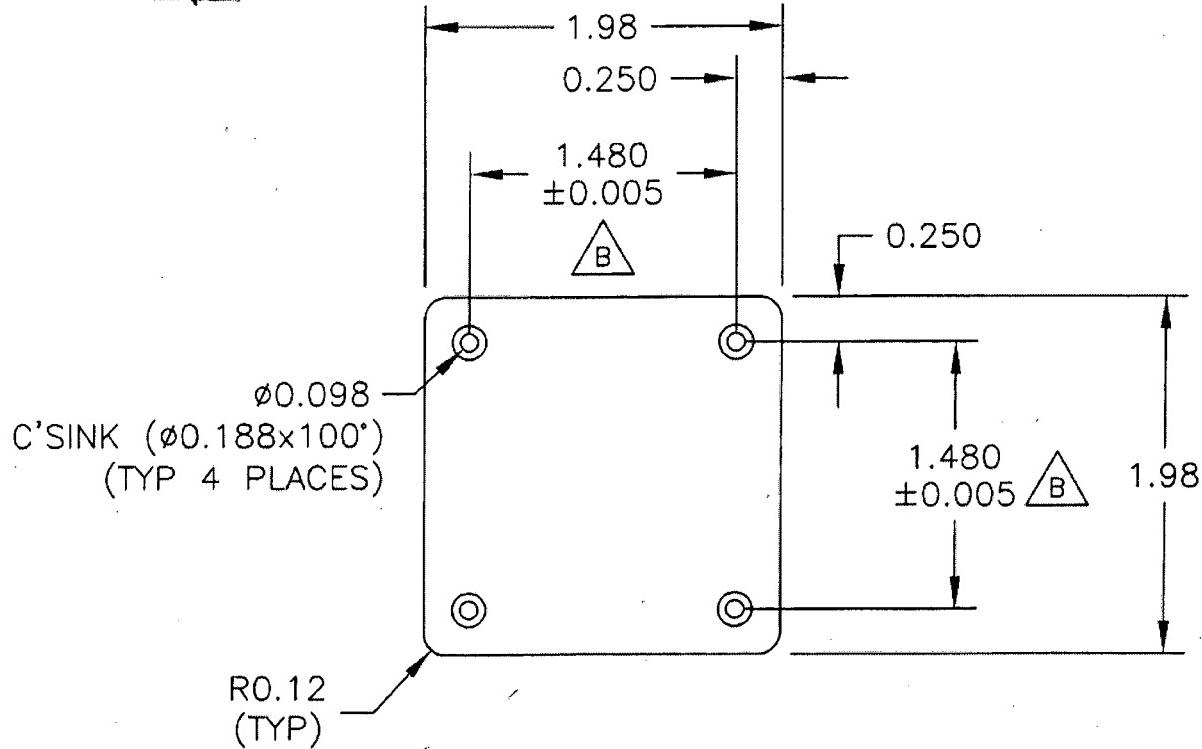
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/110)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 31661

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31	TITLE	SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-COPY  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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